



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D4775-041**  
**Job Sheet 202648**



**Part No:** D4775-041

**Job Qty:** 4 pcs

**Part Name:** Strut Assembly



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 10/31/19

**Job Tracking No:**

**Due Date:** 11/26/19

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD  
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD  
VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op<br>No | Operation              | Qty   | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign-off    |
|----------|------------------------|-------|------------|-------------|--------------|------------|-----------------------|-----------|-------------|
|          |                        |       |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |             |
| 110      | Packaging 1 - Pick Kit | 4 pcs |            | 11/26/19    | 0.00         | 0.00       | Packaging 1 - 1       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 2       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 3       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 4       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 5       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 6       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 7       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 8       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 9       |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 10      |           | NOV 12 2019 |
|          |                        |       |            |             |              |            | Packaging 1 - 11      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 12      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 13      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 14      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 15      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 16      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 17      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 18      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 19      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 20      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 21      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 22      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 23      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 24      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 25      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 26      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 27      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 28      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 29      |           |             |
|          |                        |       |            |             |              |            | Packaging 1 - 30      |           |             |

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## [Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

|                                 |             |          |           |  |                         |       |
|---------------------------------|-------------|----------|-----------|--|-------------------------|-------|
|                                 |             |          |           |  | Packaging 1 - 31        |       |
|                                 |             |          |           |  | Packaging 1 - 32        |       |
|                                 |             |          |           |  | Packaging 1 - 33        |       |
|                                 |             |          |           |  | Packaging 1 - 34        |       |
|                                 |             |          |           |  | Packaging 1 - 35        |       |
|                                 |             |          |           |  | Packaging 1 - 36        |       |
|                                 |             |          |           |  | Small Fab - 1 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 2 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 3 - B4B     |       |
| 120 Small Fab - 2 - B4B         | 4 pcs       | 11/26/19 | 0.00 1.66 |  | Small Fab - 4 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 5 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 6 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 7 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 8 - B4B     |       |
|                                 |             |          |           |  | Small Fab - 9 - B4B     |       |
|                                 |             |          |           |  | QC 5 - 10               |       |
|                                 |             |          |           |  | QC 5 - 12               |       |
|                                 |             |          |           |  | QC 5 - 17               |       |
| 130 QC 5                        | 4 pcs       | 11/26/19 | 0.00 0.00 |  | QC 5 - 18               |       |
|                                 |             |          |           |  | QC 5 - 19               |       |
|                                 |             |          |           |  | QC 5 - 22               |       |
|                                 |             |          |           |  | QC 5 - 24               |       |
|                                 |             |          |           |  | QC 5 - 3                |       |
|                                 |             |          |           |  | QC 5 - 43               |       |
|                                 |             |          |           |  | QC 5 - 49               |       |
|                                 |             |          |           |  | QC 5 - 51               |       |
|                                 |             |          |           |  | QC 5 - 58               |       |
| 140 Packaging 3-1 - Stock - B4B | 4 pcs       | 11/26/19 | 0.00 0.00 |  | QC 5 - 68               |       |
|                                 |             |          |           |  | QC 5 - 9                |       |
|                                 |             |          |           |  | QC 5 - 50               |       |
|                                 |             |          |           |  | QC 5 - 30               |       |
|                                 |             |          |           |  | QC 5 - 40               |       |
|                                 |             |          |           |  | QC 5 - 61               |       |
|                                 |             |          |           |  | QC 5 - 81               |       |
|                                 |             |          |           |  | Packaging 3 - 1 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 2 - B4B   |       |
| Oscar                           | NOV 21 2019 |          |           |  | Packaging 3 - 3 - B4B ✓ | ST357 |
|                                 |             |          |           |  | Packaging 3 - 4 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 5 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 6 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 7 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 8 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 9 - B4B   |       |
|                                 |             |          |           |  | Packaging 3 - 10 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 11 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 12 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 13 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 14 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 15 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 16 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 17 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 18 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 19 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 20 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 21 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 22 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 23 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 24 - B4B  |       |
|                                 |             |          |           |  | Packaging 3 - 25 - B4B  |       |
|                                 |             |          |           |  |                         |       |
|                                 |             |          |           |  |                         |       |
|                                 |             |          |           |  |                         |       |
|                                 |             |          |           |  |                         |       |

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NOV 14 2019

DAS  
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NOV 20 2019 9-85

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## [Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

|                |       |          |           |                        |             |
|----------------|-------|----------|-----------|------------------------|-------------|
|                |       |          |           | Packaging 3 - 26 - B4B |             |
|                |       |          |           | Packaging 3 - 27 - B4B |             |
|                |       |          |           | Packaging 3 - 28 - B4B |             |
|                |       |          |           | Packaging 3 - 29 - B4B |             |
|                |       |          |           | Packaging 3 - 30 - B4B |             |
|                |       |          |           | Packaging 3 - 31 - B4B |             |
|                |       |          |           | Packaging 3 - 32 - B4B |             |
|                |       |          |           | Packaging 3 - 33 - B4B |             |
|                |       |          |           | Packaging 3 - 34 - B4B |             |
|                |       |          |           | Packaging 3 - 35 - B4B |             |
|                |       |          |           | Packaging 3 - 36 - B4B |             |
| 150 QC 21 - SA | 4 pcs | 11/26/19 | 0.00 0.00 | QC 21 - SA - 21 ✓      | ST 357      |
|                |       |          |           | QC 21 - SA - 70        | NOV 21 2019 |
|                |       |          |           | QC 21 - SA - 53        | NOV 21 2019 |

## Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL

BATCH: 5219888 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

150 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item  | Component Name                   | Quantity      | Operation                  | Container      |
|--------------|----------------------------------|---------------|----------------------------|----------------|
| AN3-10A      | BOLT <u>ST319</u>                | 8 Ea (2 ea)   | 110-Packaging 1 - Pick Kit | <u>8212401</u> |
| D4775-1      | Strut Tube <u>ST357</u>          | 4 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | <u>8219611</u> |
| D4776-1      | Basket Strut Clevis <u>ST114</u> | 4 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | <u>8219611</u> |
| D4776-5      | Spacer <u>ST115</u>              | 16 pcs (4 ea) | 110-Packaging 1 - Pick Kit | <u>8219611</u> |
| D4777-1      | Rod End Bearing <u>ST115</u>     | 4 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | <u>8219611</u> |
| MS21042L3    | Nut <u>ST303</u>                 | 8 Ea (2 ea)   | 110-Packaging 1 - Pick Kit | <u>8219611</u> |
| MS21209-F615 | Helic-Coil <u>ST296</u>          | 4 Ea (1 ea)   | 110-Packaging 1 - Pick Kit | <u>8219611</u> |

## Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 110-Packaging 1 - Pick Kit | AN3-10A        | 8        | 141       | 0         |
|                            | D4775-1        | 4        | 41        | 0         |
|                            | D4776-1        | 4        | 63        | 0         |
|                            | D4776-5        | 16       | 72        | 0         |
|                            | D4777-1        | 4        | 23        | 0         |
|                            | MS21042L3      | 8        | 2,621     | 0         |
|                            | MS21209-F615   | 4        | 113       | 0         |

## Part Specifications

Specifications could not be found.

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

| Job: _____                       |                   | DISPOSITION                  |  | DEPARTMENT/PROCESS                  |  |                                      |  |                                                           |  |                                                 |  |
|----------------------------------|-------------------|------------------------------|--|-------------------------------------|--|--------------------------------------|--|-----------------------------------------------------------|--|-------------------------------------------------|--|
| Part No. _____                   |                   | Rework<br>Scrap<br>Use-as-is |  | Skid-tube<br>Machining<br>Large Fab |  | Cross tube<br>Small Fab<br>Finishing |  | Eng. (Non-AW)<br>Prod. Eng. Coord.<br>Rec/Store/Packaging |  | Engineering<br>Water Jet<br>Supplier<br>Quality |  |
| Date : _____                     | Sequence #: _____ | QTY Affected : _____         |  | MRB (QS1042)                        |  |                                      |  |                                                           |  |                                                 |  |
| Description Work Order Deviation |                   |                              |  | Disposition                         |  |                                      |  |                                                           |  |                                                 |  |
|                                  |                   |                              |  |                                     |  |                                      |  |                                                           |  |                                                 |  |
|                                  |                   |                              |  |                                     |  |                                      |  |                                                           |  |                                                 |  |
|                                  |                   |                              |  |                                     |  |                                      |  |                                                           |  |                                                 |  |
| Completed By                     |                   |                              |  | Lead hand / Supervisor              |  |                                      |  |                                                           |  |                                                 |  |
| QC / QA Coordinator              |                   |                              |  |                                     |  |                                      |  |                                                           |  |                                                 |  |
| <b>Root Cause</b>                |                   |                              |  | <b>FAULT CATEGORY</b>               |  |                                      |  |                                                           |  |                                                 |  |
| Operator                         |                   |                              |  | Pressure/Forced                     |  | Contamination                        |  | Power Loss/Surge                                          |  | Positioned Wrong                                |  |
| Manufacturing Process            |                   |                              |  | Bending                             |  | Misaligned/off center                |  | Folio/Program                                             |  | Outside Tolerance                               |  |
| Equip/Tooling                    |                   |                              |  | Crushing                            |  | BOM/Route                            |  | Grain Direction                                           |  | Drawing                                         |  |
| Handling/Preservation            |                   |                              |  | Cracks                              |  | Broken/Damage/Defect                 |  | Weld                                                      |  | Finish                                          |  |
| Material                         |                   |                              |  | Crimp/Kink/Ripple/Wave/Twist        |  | Incomplete/Unclear Instructions      |  | Wrong Stock Pulled                                        |  | Part Lost/Missing                               |  |
| Product Improvement              |                   |                              |  | Marks/Chatter                       |  | Drill Holes                          |  | Out of Sequence                                           |  | Misread                                         |  |
| Process Improvement              |                   |                              |  | Mislabeled                          |  | Fit/Function                         |  | Off-set/Set-up                                            |  |                                                 |  |
| Human Factors                    |                   |                              |  | Other/Details:                      |  |                                      |  |                                                           |  |                                                 |  |